

Work Order ID 108862

November-11-13 9:04:24 AM

108862

Page 1

Item ID: D206-642-251

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|---------|
| D3804 | A (DEO) |
|-------|---------|

| | |
|--------------|---|
| IIN-D206-642 | O |
|--------------|---|

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-251

CHG002

SCRAP*Scrapped*

Work Order ID: 108862

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Item ID: D206-642-251

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13 Start Qty: 1.00 *1*

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Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

010

0.00

110

Skidtubes

0.00

Skidtubes

Memo

1-Debur Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod m126325/m122324

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

DEC 13 / 11 / 11

BE 13 / 11 / 12

DGL 13-11-12.

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Item ID: D206-642-251

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

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Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

13-11-13 DGL

PTO

120 QC6- Inspect dimensions to drawing 0.00

120

QC Memo 0.00

Quality Control

108862

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/24/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/29/13 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00

130

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open crossbolt holes to Ø0.3125"

2- Open Aft cap'hole #6.

****no wearplate holes for this skidtube****

3-Deburr tube and blow out chips from inside the tube

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

DQA:

Date: 14/01/02



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ☒

Date: 13/12/27

Work Order update only ☐

| | | |
|---|---|---|
| Work Order: <u>108862</u> Part No. <u>D206-642-251</u> NCR No. <u>13-3385</u> | DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS Skid-tube <input checked="" type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
|---|---|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|-------------------------------------|------|-----|---|-------------------|--------------------|--------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | 13-11-12 | 110 | 1 | 14 holes ovalised while drilling stainless steel doubler. | | SCRAP | DGL 13-12-11 | | DAS 16 9-89 |
| Operator | <input checked="" type="checkbox"/> | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | <input checked="" type="checkbox"/> | | | RC; New employee, Training lack of experience. | | 624.78 | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | | |
|---|---|--|---|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Folio/Program | <input type="checkbox"/> Outside Dimensions |
| <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Grain | <input type="checkbox"/> Over/Under tolerance |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Hardware | <input type="checkbox"/> Part Incorrect |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Part Lost/Missing |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Moved |
| <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Positioned Wrong |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Power Loss/Surge |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | <input type="checkbox"/> Misread | <input type="checkbox"/> Pressure/Forced |
| <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Off-set | <input type="checkbox"/> Set-up |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Calibration | <input type="checkbox"/> Temperature/Cure |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Weld |
| | | | <input type="checkbox"/> Wrong Stock Pulled |
| | | | <input type="checkbox"/> Other |

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Quality Control

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Item ID: D206-642-251

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/29/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: _____ Time: _____

Finish Date: _____ Time: _____

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 _____

Sikaflex expire date: _____

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

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Item ID: D206-642-251

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Remove alodine per DEO detail B from around hole and prepare for welding

2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod _____

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod _____

5-Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/24/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/29/13 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

210

0.00

210

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

220

| | |
|--|------|
| QC9- Inspect visual per QSI004- Fusion Welds | 0.00 |
|--|------|

0.00

220

QC

Memo

0.00

Quality Control

230

| | |
|---|------|
| QC5- Inspect part completeness to step on W/O | 0.00 |
|---|------|

0.00

230

QC

Memo

0.00

Quality Control

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Quality Control

Work Order ID 108862

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Item ID: D206-642-251 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)
 Start Date: 10/24/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/29/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 270 | | 0.00 | | | | | | | |
| *270* | HandFinishing | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. | | | | | | | | |
| 280 | | 0.00 | | | | | | | |
| *280* | HandFinishing | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 _____ Sikaflex expire date: _____ | | | | | | | | |
| | 2- Install wearplate as per dwg | | | | | | | | |
| | 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: _____ | | | | | | | | |

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Item ID: D206-642-251

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Stop *NS2*

Start Date: 10/24/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 290 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *290* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 300 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *300* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 310 | | 0.00 | | | | | | | |
| *310* | Packaging | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D206-642-251 | | | | | | | | |
| | Location: _____ | | | | | | | | |
| | PPP Rev: _____ | | | | | | | | |

Work Order ID 108862

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Item ID: D206-642-251

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

320

QC21- Final Inspection - Work Order Release

0.00

320

QC

Memo

0.00

Quality Control

PL 13-12-18

Picklist Print

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Page 1

Work Order ID: 108862

Parent Item: D206-642-251

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.17 PER IIN REVO DD VERF:EC
per ecn12-679 DD verf:JLM

IPP Rev:B 12.11.22 now swage

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D4720-1 Spacer | | Manufactured | No | | | 200 | Each | 643.0000 | 19 | 19 | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 643 | |
| 102892 | 7 | |
| 103902 | 552 | |
| 93766 | 21 | |
| 97123 | 39 | |
| 99685 | 24 | |

| | | | | | | | | | | | | | |
|---------------------------------|--|--------------|----|--|--|-----|------|---------|--|--|--|--|--|
| D2620 Skidtube, 206 Skidtube | | Manufactured | No | | | 110 | Each | 24.0000 | | | | | |
|---------------------------------|--|--------------|----|--|--|-----|------|---------|--|--|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 24 | |
| 106248 | 1 | |
| 108384 | 20 | |
| 91134 | 1 | |
| 93646 | 1 | |
| 93647 | 1 | |

| | | | | | | | | | | | | | |
|--------------------|--|--------------|----|--|--|-----|------|----------|---|---|--|--|--|
| D3286-1 Doubler | | Manufactured | No | | | 110 | Each | 126.0000 | 2 | 2 | | | |
|--------------------|--|--------------|----|--|--|-----|------|----------|---|---|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG002 | 126 | |
| 74872 | 6 | |
| 76772 | 6 | |
| 78014 | 6 | |
| 90503 | 19 | |
| 91158 | 89 | |

DC 13/11/11

(1)

(2)

13-11-13 DEL

Picklist Print

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Work Order ID: 108862

Parent Item: D206-642-251

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

D2647

Manufactured No

110

Each

35.0000

1

1

Cap

Location

Loc Qty

Loc Code

LG002

35

102371

15

103459

3

107588

15

75482

2

CR3212-4-04

Purchased No

180

Each

2,710.0000

52

52

Cherry Rivet

Location

Loc Qty

Loc Code

ST328

542

119075

50

123265

492

st552

2168

m126534

1190

m126691

978

D2654-3

Manufactured No

180

Each

7.0000

1

1

Web

Location

Loc Qty

Loc Code

LG

7

105172

6

95347

1

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Picklist Print

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Work Order ID: 108862

Parent Item: D206-642-251

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

590.0000

1

1

Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

478

107906

208

108633

196

93662

74

LG001

16

106886

12

90967

1

91191

3

LG002

96

82813

40

85586

4

86912

3

88529

15

90333

7

90497

6

93663

21

D3286-3

Manufactured No

200

Each

87.0000

2

2

Spacer

Location

Loc Qty

Loc Code

LG

84

91160

84

LG001

3

74117

1

79557

1

90504

1

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Picklist Print

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Work Order ID: 108862

Parent Item: D206-642-251

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

210

Each

351.0000

2

2

Cherry Rivet

Location

Loc Qty

Loc Code

FP001

5

122973

5

ST327

346

124259

14

m126282

134

m126333

198

CR3212-4-03

Purchased

No

210

Each

1,150.0000

2

2

Cherry Rivet

Location

Loc Qty

Loc Code

ST328

1150

114889

24

119017

700

123265

424

123301

2

D2680-041

Manufactured

No

210

Each

5.0000

1

1

Nut Plate

Location

Loc Qty

Loc Code

ST014

5

103551

2

91162

3

D3805-043

Manufactured

No

270

Each

9.0000

1

1

Wearplate Ass'y Fwd High Gear

Location

Loc Qty

Loc Code

FP001

2

77584

2

FP-001

2

86277

2

FP002

5

86277

5

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Shop Packet Print

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Picklist Print

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Work Order ID: 108862

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Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|-------------------------------|--------------|----|-----|------|--------|---|---|
| D3805-047 | Manufactured | No | 270 | Each | 3.0000 | 1 | 1 |
| Wearplate Ass'y Aft High Gear | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 3 | |
| 77585 | 2 | |
| 88968 | 1 | |

| | | | | | | | |
|---------|-----------|----|-----|------|----------|---|---|
| AN3-37A | Purchased | No | 270 | Each | 255.0000 | 7 | 7 |
| Bolt | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 10 | |
| 119086 | 10 | |
| ST513 | 245 | |
| 123355 | 245 | |

| | | | | | | | |
|---------------|-----------|----|-----|------|------------|---|---|
| NAS1149C0332R | Purchased | No | 270 | Each | 13,051.000 | 7 | 7 |
| WASHER | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 264 | |
| 123355 | 264 | |
| ST292 | 119 | |
| 123248 | 18 | |
| 123759 | 10 | |
| 125268 | 91 | |
| st510 | 10776 | |
| m126319 | 5276 | |
| m127306 | 2500 | |
| m127410 | 3000 | |
| ST511 | 1766 | |
| 125654 | 1766 | |
| ST517 | 126 | |
| 124580 | 126 | |

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Picklist Print

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Page 6

Work Order ID: 108862

Parent Item: D206-642-251

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

270

Each

7,806.0000

7

7

Nut

Location

Loc Qty

Loc Code

ST314

1035

M126036

35

M127304

1000

ST506

814

123900

814

ST509

3000

M127410

3000

ST510a

2957

M126275

8

M126333

2949

D3873-1

Manufactured

No

270

Each

421.0000

14

14

Bushing

Location

Loc Qty

Loc Code

FP002

4

90492

4

ST067

404

104858

84

105611

300

93658

20

ST069

13

91188

11

93659

2

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Page 6

Picklist Print

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Page 7

Work Order ID: 108862

Parent Item: D206-642-251

Start Date: 10/24/13

Required Date: 10/29/13

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

270

Each

2,993.0000

2

2

Washer

Location

Loc Qty

Loc Code

ST293

1607

125268

7

m123374

600

m127431

1000

ST294

386

122973

75

125044

8

m125807

303

ST511

1000

m127389

1000

MS27039-1-08

Purchased

No

270

Each

1,327.0000

2

2

Screw

Location

Loc Qty

Loc Code

GA

1

117423

1

ST305

3

121243

3

ST506

36

124326

36

st507

1283

m126319

783

m127255

500

ST509

4

125654

4

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Page 7

Picklist Print

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Page 8

Work Order ID: 108862

Parent Item: D206-642-251

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

D2651-1
Plug

Manufactured No

270 Each

568.0000

8

8

Location

Loc Qty

Loc Code

FP

200

104843

200

FP001

368

103305

18

103858

114

106456

136

57869

1

66445

10

69018

2

70827

2

77559

31

78124

5

78584

14

79234

4

81954

6

85456

3

93664

9

96854

1

98156

12

D2651-3
O-Ring

Manufactured No

270 Each

649.0000

8

8

Location

Loc Qty

Loc Code

FP

326

104725

126

104726

200

FP001

323

102315

120

108583

175

61962

12

73828

4

90507

4

98907

8

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Picklist Print

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Page 9

Work Order ID: 108862

Parent Item: D206-642-251

Start Date: 10/24/13

Required Date: 10/29/13

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

270

Each

105.0000

1

1

Screw

Location

Loc Qty

Loc Code

ST307

105

123355

5

m126534

100

NAS1149D0463J

Purchased

No

270

Each

2,319.0000

1

1

WASHER

Location

Loc Qty

Loc Code

FP001

2

122441

2

ST007

24

121912

24

ST294

1547

119097

1

124198

35

124778

83

M127255

1428

ST510a

746

M126221

746

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Page 10

Work Order ID: 108862

Parent Item: D206-642-251

Start Date: 10/24/13

Required Date: 10/29/13

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

93.0000

1

1

Aft Cap

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

89

103306

19

107857

42

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

79562

2

85443

2

85848

2

91189

5

93661

1

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Page 10

| ITEM | Qty -041 | Qty -043 | Part Number | Description |
|------|-------------|-------------|--------------|---------------------------------|
| 1 | X | | D3804-041 | SKIDTUBE ASSEMBLY, 206 A/B LOW |
| 2 | | X | D3804-043 | SKIDTUBE ASSEMBLY, 206 A/B HIGH |
| 5 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 6 | 1 | 1 | D2646 | AFT CAP |
| 7 | 1 | 1 | D2647 | CAP |
| 8 | 19 | 20 | D2649 | CROSS BOLT SPACER |
| 9 | 6 | 8 | D2651-1 | PLUG |
| 10 | 6 | 8 | D2651-3 | O-RING |
| 11 | | 1 | D2654-3 | WEB |
| 12 | 1 | | D2654-1 | WEB |
| 13 | 1 | 1 | D2680-041 | NUT PLATE |
| 14 | 2 | 2 | D3286-1 | DOUBLER |
| 15 | 2 | 2 | D3286-3 | STUD |
| 21 | 2 | 2 | AN960JD10L | WASHER |
| 22 | 1 | 1 | AN960JD416 | WASHER |
| 23 | 2 | 2 | CCR264SS3-3 | RIVET |
| 24 | 2 | 2 | CR3212-4-03 | RIVET |
| 25 | 52 | 52 | CR3212-4-04 | RIVET |
| 26 | 2 | 2 | MS27039-1-08 | SCREW |
| 27 | 1 | 1 | MS27039-4-06 | SCREW |

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

108862 MCT
13-10-30

DEO ATTACHED

RELEASED

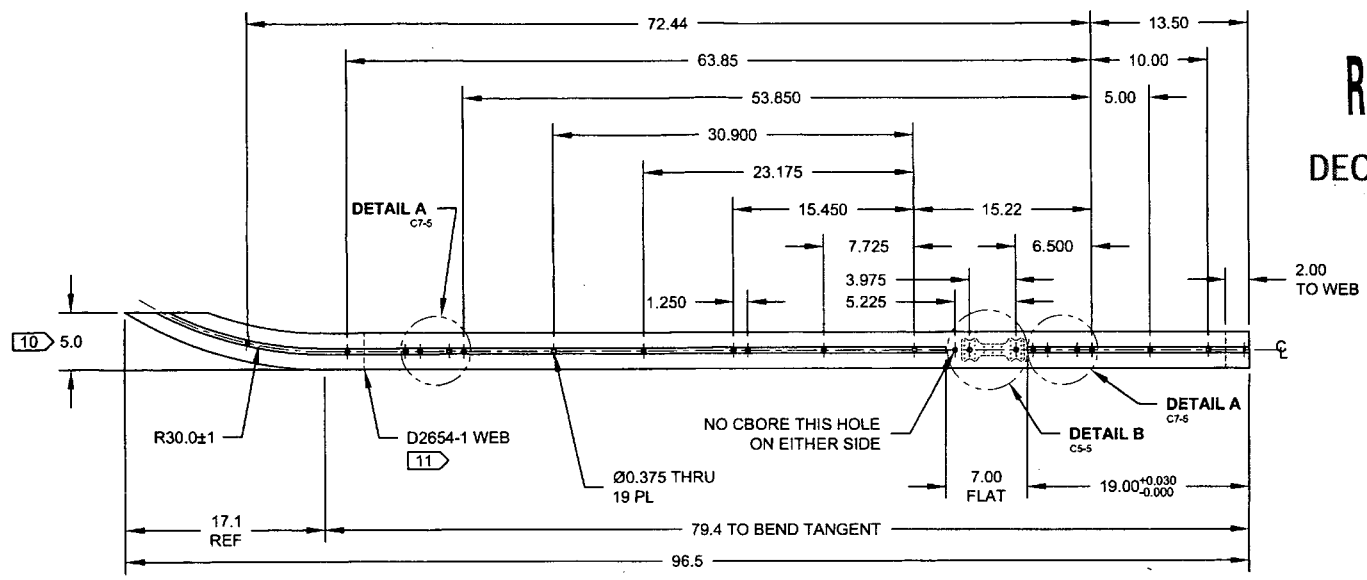
09.03.07
per ECN 09-536

| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | MB | 08.07.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 99 | DART AEROSPACE USA, INC | |
| DRAWN | 99 | PORT HADLOCK, WA | |
| CHECKED | 99 | DRAWING NO. | REV. A |
| MFG. APPR. | 99 | D3804 | SHEET 1 OF 5 |
| APPROVED | 99 | TITLE | SCALE |
| DE APPR. | 99 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

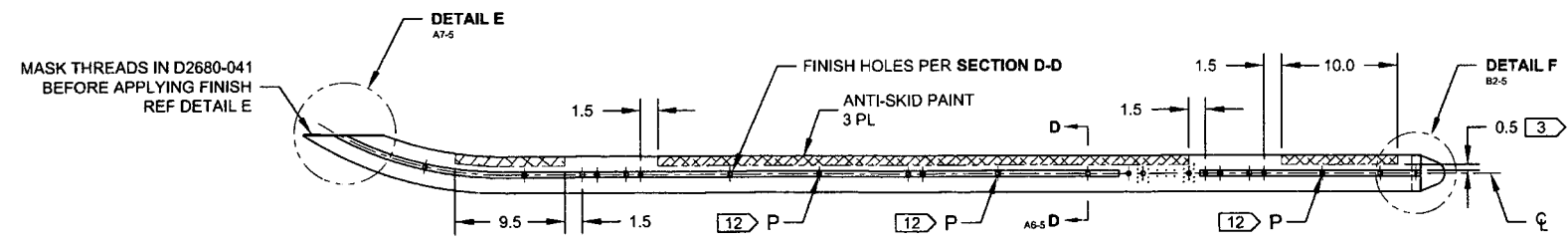
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09.03.03

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D3804-041 BENDING/DRILLING DETAIL

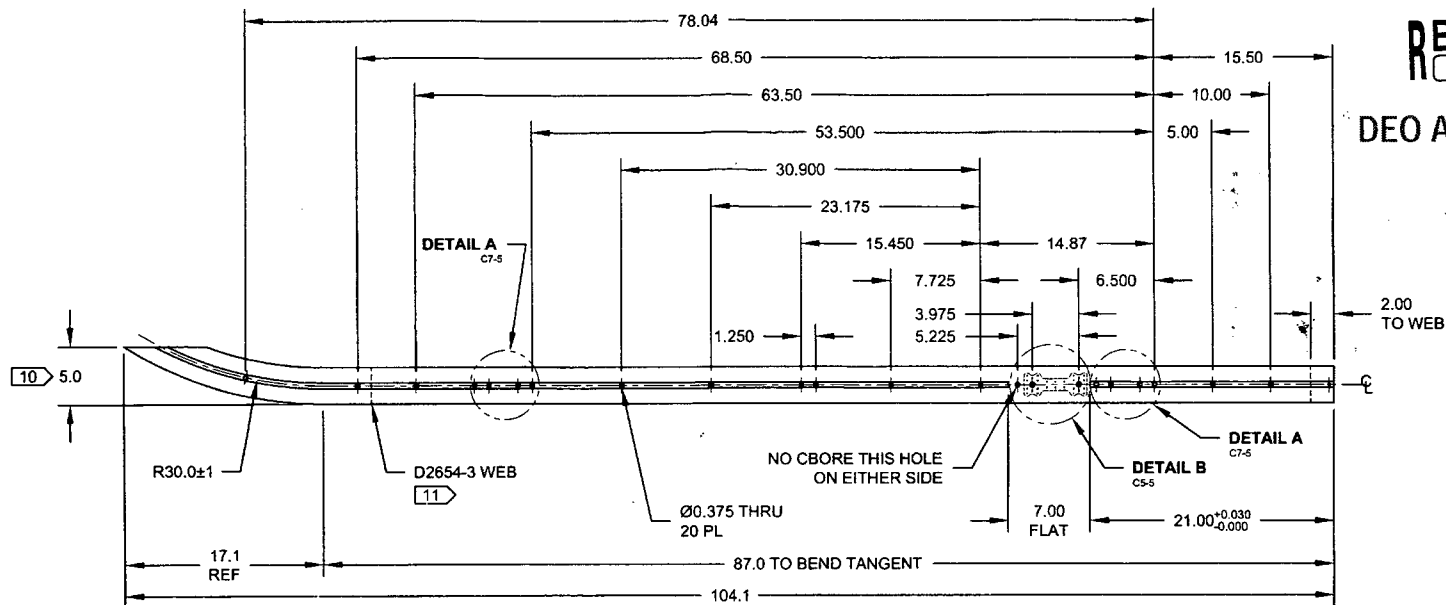


D3804-041 ASSEMBLY/FINISHING DETAIL

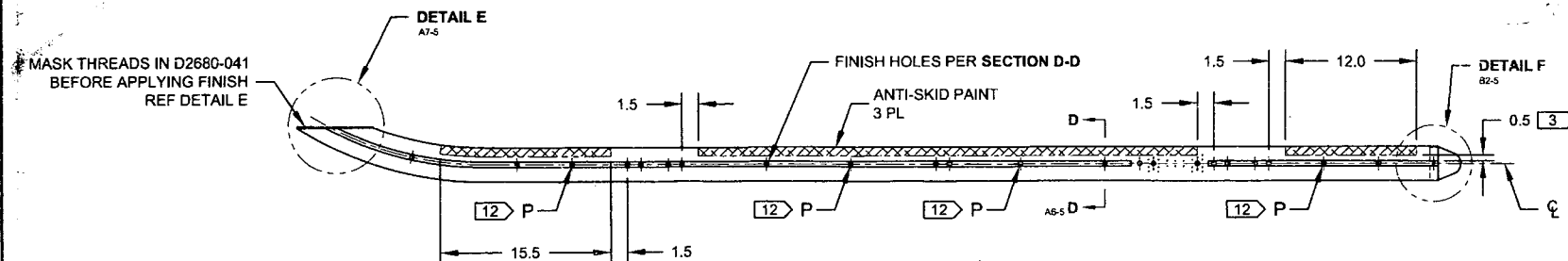
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| DESIGN | 91 | DART AEROSPACE USA, INC | |
| DRAWN | 1 | PORT HADLOCK, WA | |
| CHECKED | 1 | DRAWING NO. | REV. A |
| MFG. APPR. | 1 | D3804 | SHEET 2 OF 5 |
| APPROVED | 1 | TITLE | SCALE |
| DE APPR. | 1 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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D3804-043 BENDING/DRILLING DETAIL

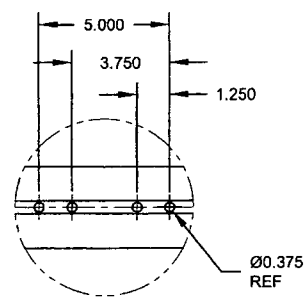


D3804-043 ASSEMBLY/FINISHING DETAIL

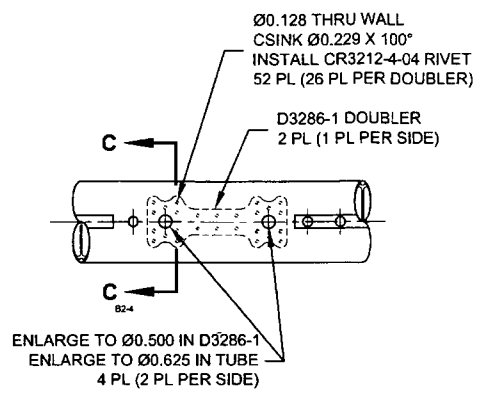
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| DRAWN | 5 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 8 | D3804 | SHEET 3 OF 5 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 11 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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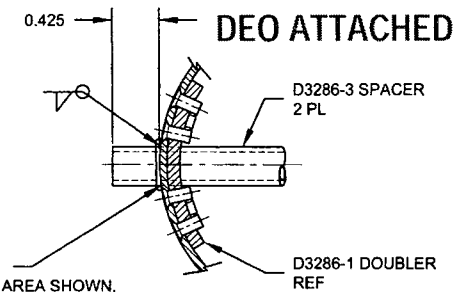
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UP 09.03.07



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

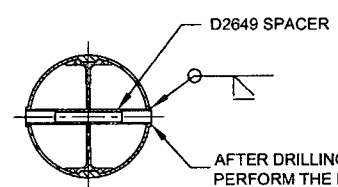


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

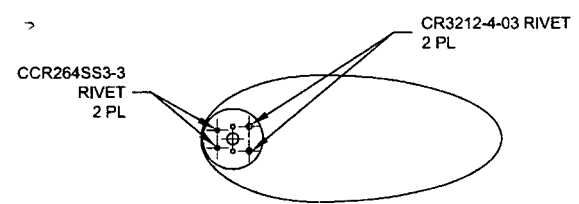
- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORER TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

| | | | |
|------------|----------|--|--------------|
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | J | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | E | D3804 | SHEET 4 OF 5 |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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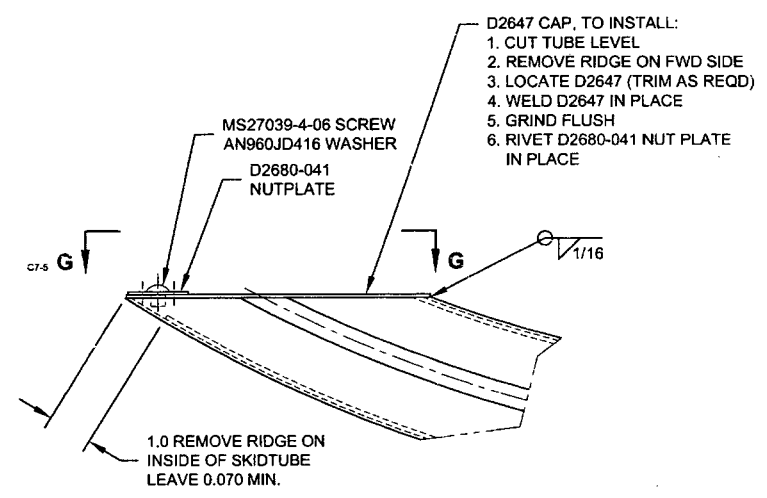
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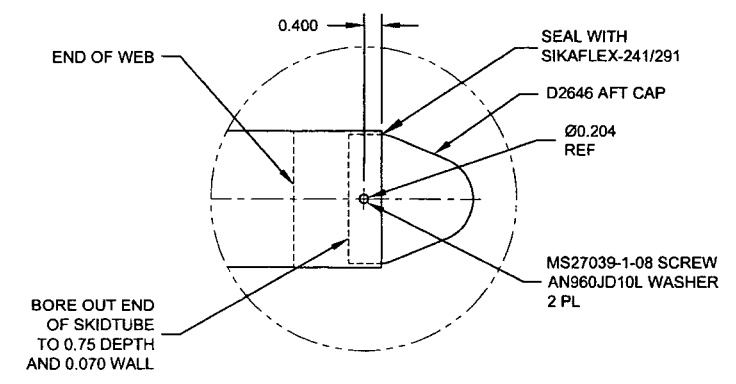
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VIEW G-G
SCALE NONE
A7-5



DETAIL E
SCALE NONE
B7-2
B7-3



DETAIL F
SCALE NONE
B2-2
B2-3

| | | | |
|------------|----------|--|--------------|
| DESIGN | 91 | DART AEROSPACE USA, INC | |
| DRAWN | 91 | PORT HADLOCK, WA | |
| CHECKED | 91 | DRAWING NO. | REV. A |
| MFG. APPR. | 91 | D3804 | SHEET 5 OF 5 |
| APPROVED | 91 | TITLE | SCALE |
| DE APPR. | 91 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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108862

| | | | | | | |
|----------------------|--------------------------------------|----------------------------------|---|--------------------------------|---------------------------|--------------|
| DRAWING NO. D3804 | TITLE SKIDTUBE ASSEMBLIES, 206A/B | REV. A | DART AEROSPACE LTD ENGINEERING ORDER | D.E.O. NO. D3804-A-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>CP</i> | CHECKED <i>AP</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DE APPR. <i>[Signature]</i> | | |
| DATE 12.10.12 | DATE 12.10.22 | DATE 12.10.22 | DATE 12.10.22 | DATE 12.10.22 | | |

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

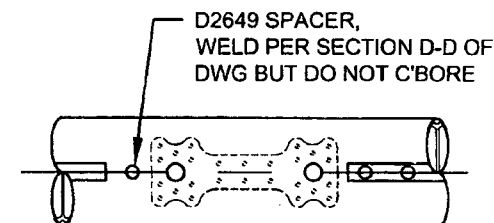
IS:

| QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------------|
| 1 | 1 | D2649 | CROSS BOLT SPACER |
| 18 | 19 | D4720-1 | SPACER |

WAS:

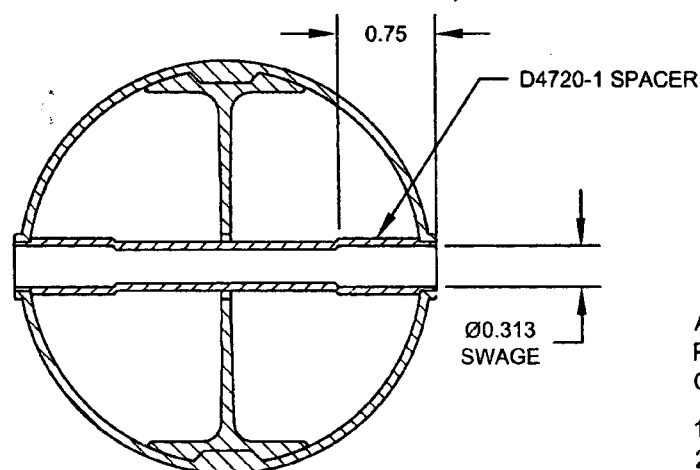
| | | | |
|----|----|-------|-------------------|
| 19 | 20 | D2649 | CROSS BOLT SPACER |
|----|----|-------|-------------------|

ADD SECTION H-H BELOW, WHICH IS THE SAME SECTION VIEW AS SECTION D-D OF DWG.
C'BORED HOLES ARE **NOW SWAGED** PER SECTION H-H BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER SECTION D-D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE



SECTION H-H

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 18 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

RELEASE
2012-11-16
[Signature]

